

Date: Monday, 27/08/2007 2:53:55 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : DISASSEMBLE
Job Number : 34266	
Estimate Number : 10804	
P.O. Number : NIA	Part Number : D3562041
This Issue : 27/08/2007 S.O. No. : NIA	Drawing Number : D412-630-033
Prsht Rev. : NC	Project Number : NIA
First Issue : 27/08/2007 Type : LARGE FAB ASSY	Drawing Revision : NIA
Previous Run : 00015	Material : NIA
Written By : _____	Due Date : 03/09/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

1 X D412-630-033 B

32715

NIA

27-08-07

2.0	D412630033	HELI ACCESS STEP, LH FOLDING
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HELI ACCESS STEP, LH FOLDING

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

DISASSEMBLE D2803/D2804 BRACKET ASS'YS

B

MF

07-08-07

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

27-08-07 (1)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REPACKAGE AS D3562-041

RESTOCK PARTS

27/8/28 (1)

Date: Monday, 27/08/2007 2:53:55 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: DISASSEMBLE

Job Number: 34266

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

*See 32715
for parts to return to stock*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

REPLACEMENT STEP WELDMENT FOR B/N 27269

ISSUE RED DECAL - D412-630-034 B34266

NEW PAPERWORK REQ'D

U 0708.27

Job Completion



QC 21

FINAL inspection W/O release

U 0708.28

0710/28

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32715
Estimate Number : 12567
P.O. Number : N/A
This Issue : 5/31/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 32713
Written By :
Checked & Approved By : 07.05.31
Comment : Est. Rev. A New Issue 06-11-08 JLM

Drawing Name : HELI-ACCESS STEP LH (FOLDING)
Part Number : D412630033
Drawing Number : IIN D412-630 REV K
Project Number : N/A
Drawing Revision : K
Material : N/A
Due Date : 6/30/2007 Qty: 5 Um: 6 Each

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG002

K-S 07-06-05

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

1529883

3854

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

B 29391

13 29391

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

27561

7/2/11SP

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32715

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2807	Support Prop
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

128488

27562

6.0	D2813	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

1729396

7.0	D3562041	STEP ASSEMBLY, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-041	Step Weldment LH

Batch

032719

8.0	D33951	Bushing
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

128455

3*

9.0	AN3C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

1100695

1101189

7/7/1150

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32715

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty Part Number Description
2 AN8C16 Bolt

Batch

4
M100695 ✓

2X

M102736

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty Part Number Description
2 AN310C8 Nut

Batch

(4) ✓
M100433

(2) X

M102728

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number Description
2 MS24665-302 Cotter Pin (or AN380C3-4)

Batch

M16941 ✓

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Pick:

Qty Part Number Description
6 NAS1515H3 Washer

Batch

M100998 ✓

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty Part Number Description
4 NAS1515H5L Washer

Batch

8
M100680 ✓

M104679

(16)

2/2/11SP

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32715

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

(4)

M101331, M102067

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M104679

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101396

7/2/11SP

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: m104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: m17045

MF

07-07-18

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/07/18 (45)

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32715

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

29393

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-3	Bushing

Batch

29394

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description
1	D2810-5	Strut

Batch

32695

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description
2	D3396-1	Spacer

Batch

29496

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description

Batch

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32715

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0 1 AN4C6A Bolt

26.0 1 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

③ ① ✓ ②
M1012736 SD M101189M

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

②
M102959 ✓ SD

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN44-C7A	Eyebolt

Batch

① ✓ 59
M101711 ✓

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

② 59
M101291 ✓

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H4	Washer

Batch

⑧ ✓
M104425 ✓ 7/7/23 59

Date: Thursday, 5/31/2007 7:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32715

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description

7 07/07/23 (5) NAS1515H5 Washer

Batch

3 1104885

7

54

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description

4 07/07/23 (5) MS21043-4 Nut

Batch

(4) 1104936

54

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description

3 07/07/23 (5) MS21043-5 Nut

Batch

(2) 101 1101418, 1104729

7/7/23

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

A

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8/07/23